

Date: Thursday, 12/06/2008 3:46:54 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LATCH BRACKET		
Job Number	39849	Part Number	D2583		
Estimate Number	10994	Drawing Number	D2583 REV. B		
P.O. Number	:	Project Number	N/A		
This Issue	12/06/2008	S.O. No.	:		
Prsht Rev.	NC	Drawing Revision	B		
First Issue	/ /	Type	SMALL /MED FAB		
Previous Run	38032	Material	:		
Written By	:	Due Date	30/06/2008	Qty:	20 Um: Each
Checked & Approved By	JUL 08. (P. D)				
Comment	Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM Est: D 06.07.21 Waterjet EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
		4.	
		Comment: Qty.: 0.1227 sf(s)/Unit Total : 2.4549 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) Batch: 106 900 HB 8-6-16	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2583 Dwg Rev: B HB 8-6-16 Prog Rev: B	(32)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		HB 8-6-16	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		S 08/06/19 (X32) counter	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		DC 08/06/16 (32)	
		Comment: NC BRAKE Deburr Form on CNC Brake as per Dwg D2583	
		S 08/06/19 (32)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/06/2008 3:46:54 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 39849

Part Number: D2583

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



S 08/06/18 (x32)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-F 08/06/19

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:35

OVEN TEMPERATURE:

320°

FINISH TIME:

11:05

Fd

08/06/23

(32)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(32X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-F 08/06/24

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 222

AS 08/06/25 (x32)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/25 (x32)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-F 08-06-25

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39849
Description: Latch Bracket	Part Number:	D2583
Inspection Dwg: D2583	Rev: B	Page 1 of 1

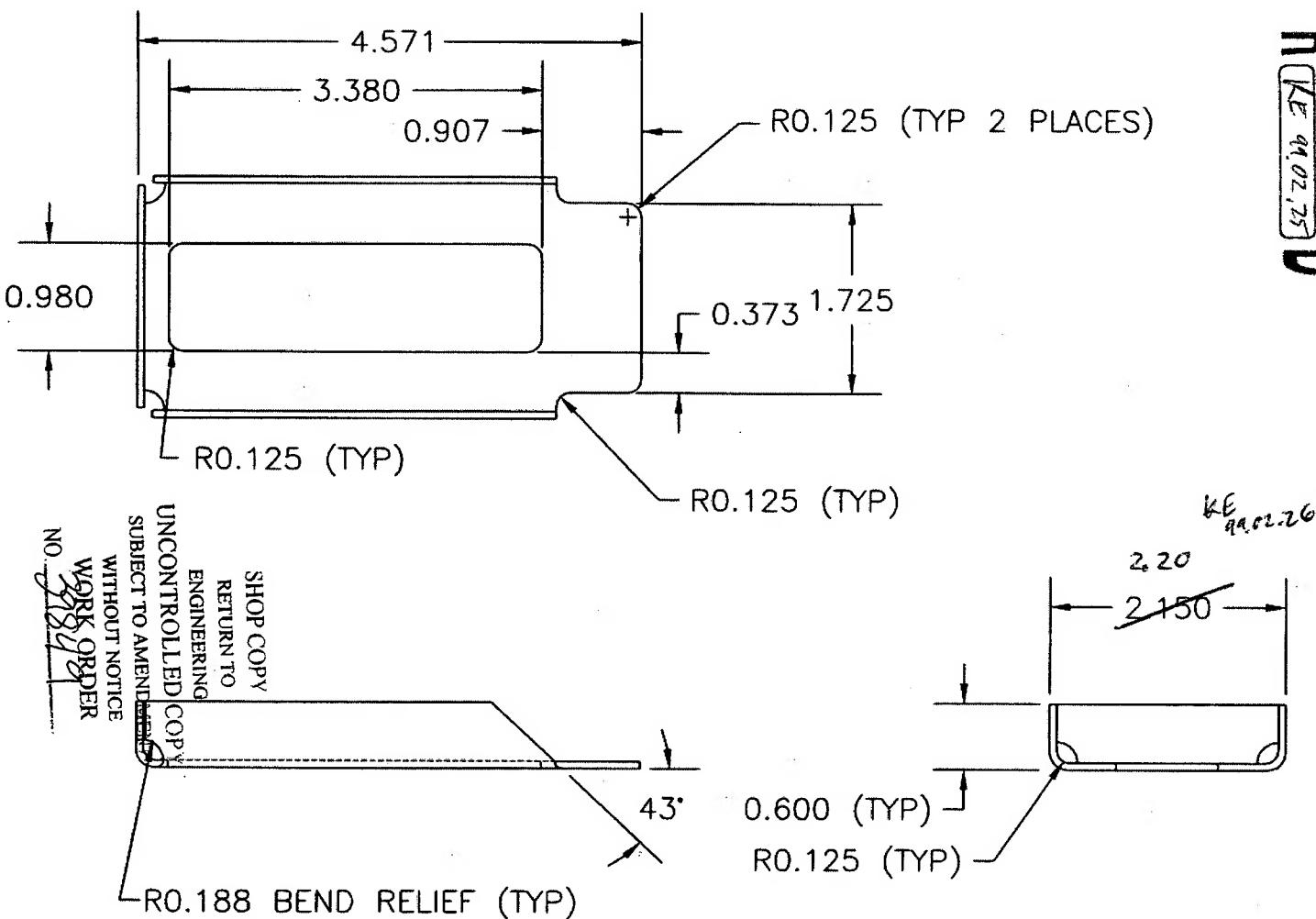
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

6

Measured by:	tB	Audited by:	d	Prototype Approval:	N/A
Date:	8-6-16	Date:	08/06/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM ✓	✓



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 KE 99.02.26

DART

COPY
RIGHT
RESERVED

DESIGN MIKE M.	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>GP</i>	APPROVED <i>KE</i>	DRAWING NO. D2583
DATE 99.02.22	TITLE LATCH BRACKET	REV. B SHEET 1 OF 1 SCALE 2:3
A 99.02.22	NEW ISSUE	
B 99.02.22	CHANGE OF FINISH (PER TSR A887)	